

2

Date: Wednesday, 12/5/2007 8:04:26 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DUAL HIGH BACK SEAT  
Job Number : 36124  
Estimate Number : 12271  
P.O. Number :  
This Issue : 12/5/2007 S.O. No. :  
Prsht Rev. : NC Part Number : D350689041  
First Issue : 1 / Type : LARGE FAB ASSY Drawing Number : IIN-D350-689 PG9  
Previous Run : 34885 Project Number : N/A  
Written By : Due Date : 1/10/2008 Qty: 1 Um: Each  
Checked & Approved By : 071205  
Comment : Est Rev:H Removed Sub-Parts 06-02-09 JLM  
Est Rev:I As per NCR 070 06-09-06 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D30231 Back Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3023-1 Back Panel ~~B36449~~ B 34898

SR 08/04/23 ①

2.0 D3017041 Back Frame Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3017-041 Back Assembly ~~B36449~~ B 34895 SR 08/04/23 ①

3.0 MS20600AD4W2 Rivet



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number Description Batch

40 ms20600ad4w2 Rivet M 4747 x 40 + 6 ml

4.0 MS20600AD4W3 Cherry Rivets



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Cherry Rivets

Batch: M 18071 x 6 + 3 ml

PTO

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-689-041 PAR #: N/A Fault Category: Prod / FAB. ASS. <sup>Med & Small</sup> NCR: Yes No DQA: D Date: 08/04/18  
QA: N/C Closed: D Date: 08/04/18

NCR: <u>36124</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/18	4	3 Rivets not long enough	<u>08.04.18</u> pv	took out and replace by 3x MS 20600 4W4 # M 107756	<u>ml</u> 08/04/18	<u>08/04/18</u>	<u>08.04.18</u> 7~	<u>08/04/18</u>
			<u>08/04/18</u>	Dut Syko flex			<u>08/04/18</u>	
08/04/18	4	7 rivets Scrap MS 20600 4W2 (maybe rivet gun?)	<u>08/04/18</u>	took out and replace New one 7x M106513 MS 20600 4W2	<u>ml</u> 08/04/18	<u>08/04/18</u>	<u>08/04/18</u>	<u>08/04/18</u>

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL HIGH BACK SEAT

Job Number: 36124

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1

GA



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per IIN 350-689-041

ml 08/04/18

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/18 (K)

7.0

POWDER COATING

POWDER COATING



M/06442



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-1 08/04/18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



118



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-22

S.014  
22/04/2008  
30 Min  
#1 1336184  
#2 1336184  
#3 D350689041  
#4  
1.26  
(X)

9.0

D30241

Spacer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D3024-1 Spacer 33368

PU

10.0

D30281

Stud



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3028-1 Stud 33369

PU

11.0

D30291

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3029-1 Spring 24962

PU 08/04/18 (1)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: DUAL HIGH BACK SEAT

Job Number: 36124

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D30301

Lock



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3030-1 Lock 24631

13.0

D30311

Loop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3031-1 Loop 33474

14.0

AN312A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN3-12A Bolt M10 3947

15.0

AN960JD10L

Washer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number Description Batch

23 AN960JD10L Washer M10 4885

16.0

MS21042L3

Nut



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number Description Batch

23 MS21042L3 Nut (or -3) M10 6883

17.0

MS24693S272

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS24693-S272 Screw M10 4746

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 36124

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

MS27039117

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS27039-1-17 Screw M/18540

*[Handwritten signature]*

19.0

MS27039119

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS27039-1-19 Screw M/10089

*[Handwritten signature]*

8/04/18

20.0

D30221

Seat Pan



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3022-1 Seat Pan B36143

B 34897

SR 08/04/23 ①

21.0

D3021041

Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3021-041 Tube Assembly B36147

B 34896

SR 08/04/23 ①

22.0

D3016041

Seat Frame Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3016-041 Frame Assembly B36145

B 34894

SR 08/04/23 ①

23.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg IIN-D350-689

*[Handwritten signature]* 08/04/23

①

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/23 (X)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Rev A -

AS 08/04/25 (X)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/28 (X)

Job Completion



mf 08-04-25

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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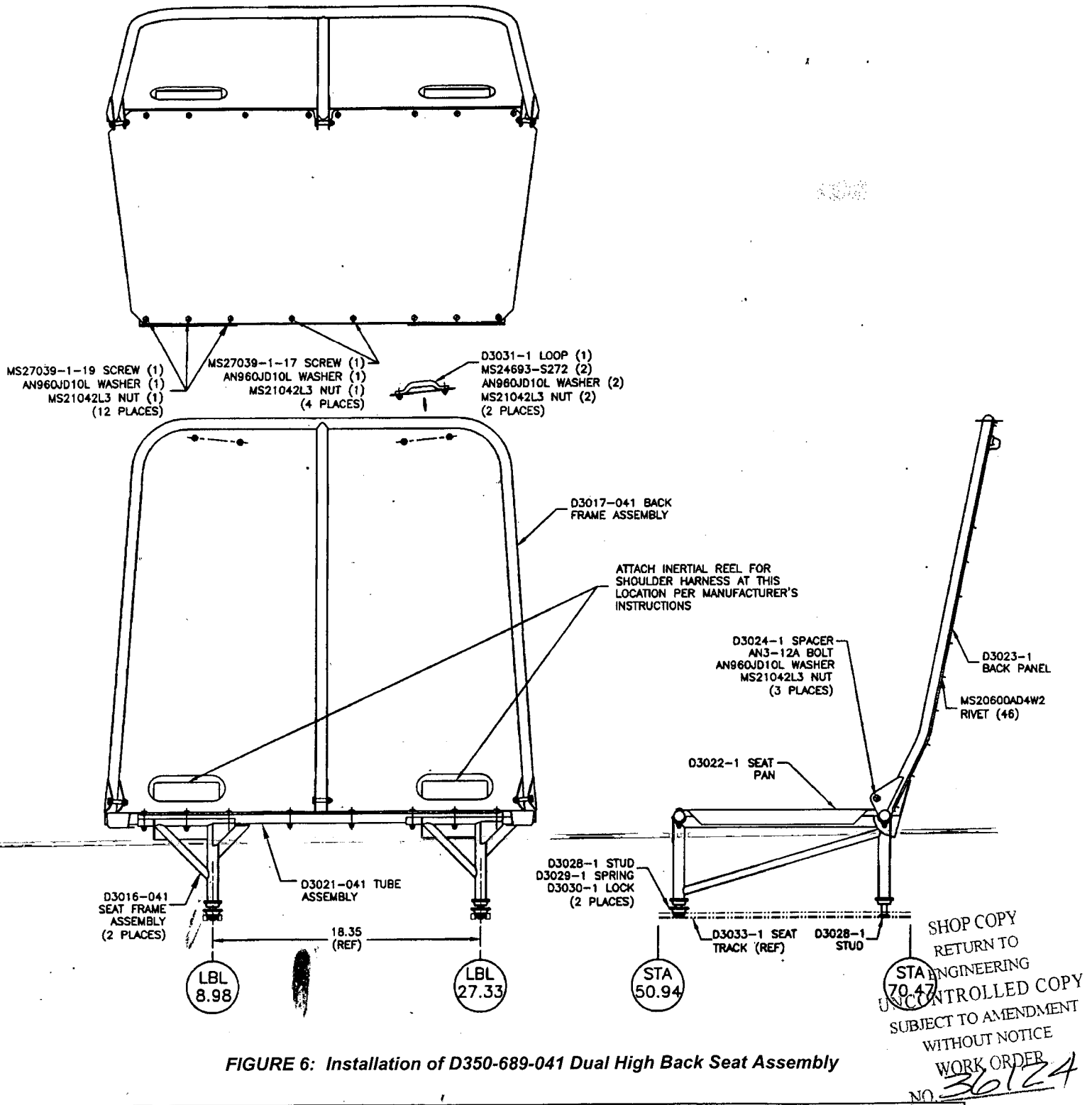


FIGURE 6: Installation of D350-689-041 Dual High Back Seat Assembly

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Revision: A  
Date: 01.05.30

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. DSI 9349	REV. A SHEET 1 OF 1
DATE 06.08.16		TITLE RIVET CHANGE	SCALE NTS
A	06.08.16	NEW ISSUE	

## **DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 Rev.A  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 Rev.0  
REF. CANADIAN STC: SH02-33  
REF. FAA STC: SR01620NY

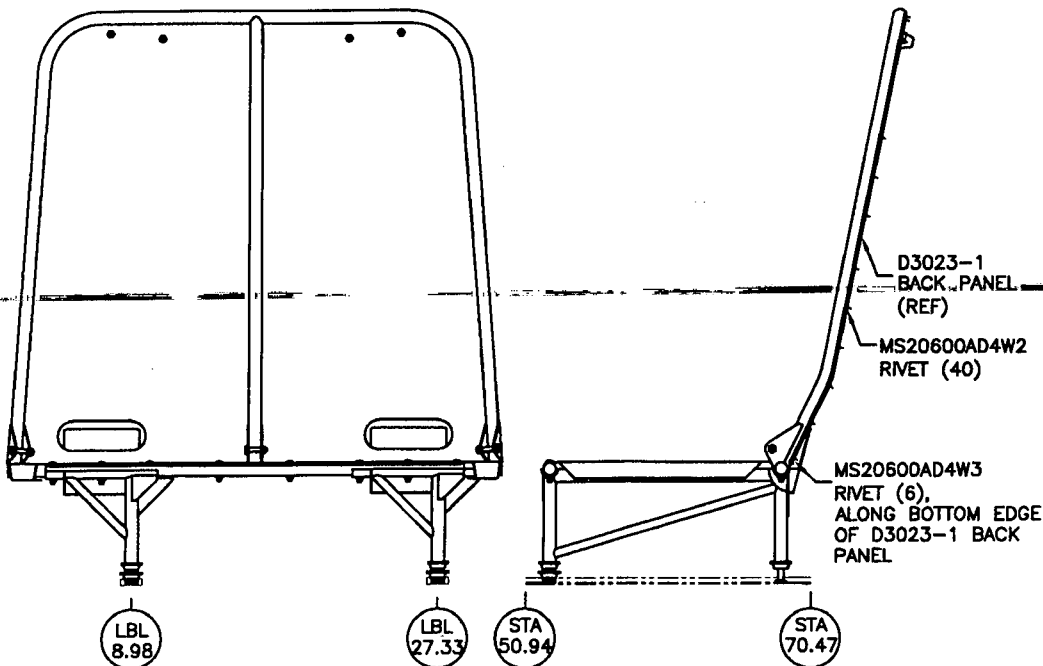
Some rivet lengths have changed, as indicated below, to ensure proper assembly of the D350-689-041 Dual High Back Seat Assembly. If installing replacement parts, it is acceptable to use longer rivets in other locations as required to ensure proper fastening. The parts list is revised as follows:

WAS:

QTY -041	Part Number	Description
X	D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
46	MS20600AD4W2	RIVET

NOW:

QTY -041	Part Number	Description
X	D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
40	MS20600AD4W2	RIVET
6	MS20600AD4W3	RIVET



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 36124

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY: *D. Shepherd*  
D. SHEPHERD (DE # 02)

DATE: 06.08.16  
CERT. NO.: SH02-33  
ISSUE NO.: 1

D350-689-041 Dual High Back Seat Assembly

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